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D3205-1
Job Sheet 194005



Part No: D3205-1
Part Name: Pedal Bracket
Part Weight: 0 lbs
Job Created: 4/24/19
Due Date: 5/3/19
Type: SOLD

Job Qty: 5 pcs
Status: New
Created By: Jennifer Renwick
Description:

Priority: Medium

Note: DWG REV C IPP A 04.06.09 New issue KJ/RF IPP Rev:B 08-12-16 attach DEO DD verified by:EC IPP REV:C AS PER REV B 12-03-23 JLM VERIFIED BY:EC

Ship Via:

Qty 1 Order 13705

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
100	Bandsaw - 1	5 pcs		5/3/19	0.00	0.57	Bandsaw - 1		SBL 19/05/27
110	HAAS 4 Axis - B4B	5 pcs		5/3/19	0.58	20.00	HAAS - 1 - B4B		SBL 19/05/27
							HAAS - 2 - B4B		
							HAAS - 3 - B4B		
							HAAS - 4 - B4B		
120	QC 2	5 pcs		5/3/19	0.00	0.00	QC 2 - 1		
							QC 2 - 12		
							QC 2 - 14		
							QC 2 - 17		
							QC 2 - 19		
							QC 2 - 2		
							QC 2 - 20		
							QC 2 - 22		
							QC 2 - 23		
							QC 2 - 25		
							QC 2 - 32		
							QC 2 - 33		
							QC 2 - 35		
							QC 2 - 39		
							QC 2 - 4		
							QC 2 - 40		
							QC 2 - 44		
							QC 2 - 45		
							QC 2 - 48		
							QC 2 - 49		
							QC 2 - 50		
							QC 2 - 51		
							QC 2 - 52		
							QC 2 - 57		SBC 19/05/27
							QC 2 - 62		
							QC 2 - 63		
							QC 2 - 8		
							QC 2 - 66		
							QC 2 - 64		
							QC 2 - 65		
							QC 2 - 5		
							QC 2 - 71		
121	Conventional Mill - 1 - B4B	5 pcs		5/3/19	0.00	5.00	Conventional Mill - 1 - B4B		DAS 19-5-27 71
							Conventional Mill - 2 - B4B		9-89

Plex 4/24/19 4:25 PM Dart.Renwick.Jennife

NCR: 19-7243



Container No: S184187
Part: D3205-1
Job No: 194005
Serial No/Batch: S184187
Revision:
Inspector:
Exp Date:
Instructions: Various STC's
Date: 06/27/19

122 QC 2	5 pcs	5/3/19	0.00	0.00	QC 2 - 1	
					QC 2 - 12	
					QC 2 - 14	
					QC 2 - 17	
					QC 2 - 19	
					QC 2 - 2	
					QC 2 - 20	
					QC 2 - 22	
					QC 2 - 23	
					QC 2 - 25	
					QC 2 - 32	
					QC 2 - 33	
					QC 2 - 35	
					QC 2 - 39	
					QC 2 - 4	
					QC 2 - 40	
					QC 2 - 44	
					QC 2 - 45	
					QC 2 - 48	
					QC 2 - 49	
					QC 2 - 50	
					QC 2 - 51	
					QC 2 - 52	
					QC 2 - 57	
					QC 2 - 62	
					QC 2 - 63	
					QC 2 - 8	DAS
					QC 2 - 66	71
					QC 2 - 64	9-89
					QC 2 - 65	
					QC 2 - 5	
					QC 2 - 71	19-5-27
130 QC 8	5 pcs	5/3/19	0.00	0.00	QC 8 - 12	
					QC 8 - 14	
					QC 8 - 17	
					QC 8 - 20	
					QC 8 - 25	
					QC 8 - 3	
					QC 8 - 32	
					QC 8 - 33	
					QC 8 - 35	
					QC 8 - 39	
					QC 8 - 4	
					QC 8 - 44	
					QC 8 - 45	
					QC 8 - 49	
					QC 8 - 58	
					QC 8 - 8	
					QC 8 - 9	
					QC 8 - 68	
					QC 8 - 67	
					QC 8 - 1 (A)	
					QC 8 - 47	
					QC 8 - 40	
					QC 8 - 52	
					QC 8 - 23	
140 Handfinish - 1-1 Chemical-B4B	5 pcs	5/3/19	0.00	0.42	Handfinish - 1 - 1 - B4B	
					Handfinish - 1 - 2 - B4B	
					Handfinish - 1 - 3 - B4B	⚡ JUN 03 7m
					Handfinish - 1 - 4 - B4B	
					Handfinish - 1 - 5 - B4B	
					Handfinish - 1 - 6 - B4B	
					Handfinish - 1 - 7 - B4B	
					Handfinish - 1 - 8 - B4B	
					Handfinish - 1 - 9 - B4B	
					Handfinish - 1 - 10 - B4B	
					Handfinish - 1 - 11 - B4B	
					Handfinish - 1 - 12 - B4B	
					Handfinish - 1 - 13 - B4B	
					Handfinish - 1 - 14 - B4B	

					Handfinish - 1 - 15 - B4B	
					Handfinish - 1 - 16 - B4B	
					Handfinish - 1 - 17 - B4B	
					Handfinish - 1 - 18 - B4B	
					Handfinish - 1 - 19 - B4B	
					Handfinish - 1 - 20 - B4B	
					Handfinish - 1 - 21 - B4B	
					Handfinish - 1 - 22 - B4B	
150 Powdercoat - 3 Grey Sand - B4B	5 pcs	5/3/19	0.00	0.42	Powdercoat - 1 - B4B	
START: 11:20 O.U.T. 300° FINISH 11:50	5 pcs	5/3/19	0.00	0.00	Powdercoat - 2 - B4B	
					Powdercoat - 3 - B4B	
					Powdercoat - 4 - B4B	
					QC 3 - 10	
					QC 3 - 13	
					QC 3 - 15	
					QC 3 - 17	
					QC 3 - 18	
					QC 3 - 2	
					QC 3 - 28	
					QC 3 - 3	
					QC 3 - 30	
					QC 3 - 34	
					QC 3 - 36	
					QC 3 - 41	
					QC 3 - 51	
					QC 3 - 58	
					QC 3 - 59	
					QC 3 - 68	
					QC 3 - 9	
					QC 3 - 40	
					QC 3 - 19	
170 Packaging 3-1 - Stock - B4B	5 pcs	5/3/19	0.00	0.00	Packaging 3 - 1 - B4B	
					Packaging 3 - 2 - B4B	
					Packaging 3 - 3 - B4B	
					Packaging 3 - 4 - B4B	
					Packaging 3 - 5 - B4B	
					Packaging 3 - 6 - B4B	
					Packaging 3 - 7 - B4B	
					Packaging 3 - 8 - B4B	
					Packaging 3 - 9 - B4B	
					Packaging 3 - 10 - B4B	
					Packaging 3 - 11 - B4B	
					Packaging 3 - 12 - B4B	
					Packaging 3 - 13 - B4B	
					Packaging 3 - 14 - B4B	
					Packaging 3 - 15 - B4B	
					Packaging 3 - 16 - B4B	
					Packaging 3 - 17 - B4B	
					Packaging 3 - 18 - B4B	
					Packaging 3 - 19 - B4B	
					Packaging 3 - 20 - B4B	
					Packaging 3 - 21 - B4B	
					Packaging 3 - 22 - B4B	
					Packaging 3 - 23 - B4B	
					Packaging 3 - 24 - B4B	
					Packaging 3 - 25 - B4B	
					Packaging 3 - 26 - B4B	
					Packaging 3 - 27 - B4B	
					Packaging 3 - 28 - B4B	
					Packaging 3 - 29 - B4B	
					Packaging 3 - 30 - B4B	
					Packaging 3 - 31 - B4B	
					Packaging 3 - 32 - B4B	
					Packaging 3 - 33 - B4B	
					Packaging 3 - 34 - B4B	
					Packaging 3 - 35 - B4B	
					Packaging 3 - 36 - B4B	
180 QC 21 - SA	5 pcs	5/3/19	0.00	0.00	QC 21 - SA - 21	
					QC 21 - SA - 70	
					QC 21 - SA - 53	

Part Op 100 - (Bandsaw) Cut blanks: 3.250" x 2.500" x 4.250" long Bar (+0.030/-0.000)

Descriptions: 110 - (HAAS CNC Vertical Machine) Machine D3205-1 as per Folio FA346 and Dwg D3205 Identify as D3205-1

120 - (QC2- Inspect parts off machine FAI/FAIB)

121 - (Manufacture as per dwg) COUNTER SINK AS PER DWG

122 - (QC2- Inspect parts off machine FAI/FAIB)

130 - (QC8- Inspect parts - second check)

140 - (Chemical Conversion Coat per QSI005 4.1)

150 - (Grey Sandtex(Ref:4.3.5.6) per QSI005 4.3) Note: Cover the thread hole for D3205-1 before powder coat.

160 - (QC3- Inspect Part Finish)

170 - (Identify as per dwg & Stock Location:) LOCATION : GA

180 - (QC21- Final Inspection - Work Order Release)

Job BOM				
Part / Item	Component Name	Quantity	Operation	Container
M7075T73B2.500X03.25	7075-T73 Bar 2.50 X 3.25	1.8230 ft (.3646 ea)	100-Bandsaw - 1	S/83 846

Job Allocations				
Operation	Component Part	Required	Inventory	Allocated
100-Bandsaw - 1	M7075T73B2.500X03.25	2	0	0

Part Specifications
Specifications could not be found.

Plex 4/24/19 4:25 PM Dart.Renwick.Jennifer

coupe 5 max
6 max

PART AEROSPACE LTD		Work Order: 194 005
Description: Pedal Bracket		Part Number: D3205-1
Inspection Dwg: D3205	Rev: C	Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
1.100	+/-0.010	1.102	✓		Vern	DAS 57 9-89 ↑
0.250	+/-0.010	.250	✓		Vern	
R0.38	+/-0.030	.385	✓		R.G.	
Ø.125	+/-0.010	.130	✓		Vern	
0.250	+/-0.010	.252	✓		Vern	
2.380	+/-0.010	2.381	✓		Vern	
1.380	+/-0.010	1.380	✓		Vern	
0.500	+/-0.010	.509	✓		Vern	
0.880	+/-0.010	.880	✓		Vern	
Ø0.470 x 100°	+0.006/-0.001	Ø.470 x 100°	✓		P.L.O.S	DAS 57 9-89 ↑
0.440	+/-0.010	.440	✓			
0.600	+/-0.010	.600	✓			
1/4-28UNF-313	N/A	1/4-28	✓			
0.250	+/-0.010	.250	✓		Vern	
Ø0.257	+0.006/-0.001	.257	✓		P.G.	
1.750	+/-0.010	1.750	✓		Vern	
0.870	+/-0.010	.870	✓		Vern	
0.440	+/-0.010	.441	✓		Vern	
R0.25	+/-0.030	.250	✓		R.G.	DAS 57 9-89 ↓
3.000	+/-0.010	3.000	✓		Vern	
3.96	+/-0.030	3.964	✓		H.G.	
0.409	+/-0.010	.410	✓		H.G.	
0.808	+/-0.010	.802	✓		H.G.	
2.562	+/-0.010	2.563	✓		Vern	

Measured by: DAS 57 9-89	Audited by: [Signature]	Preliminary Approval:
Date: 19/05/06	Date: 19/05/31	Date:

Rev	Date	Change	Revised by	Approved
A	05.02.17	New Issue	KJ/JLM	
B	12.05.14	Dimensions updated per Dwg Rev B	KJ	
C	13.02.27	Dwg Rev updated	KJ	[Signature]

DQA: _____ Date: 19/05/27 *MD 5 July 2019*

WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____ Work Order update only ☐

Work Order: <u>194 005</u>		AGAINST DEPARTMENT/PROCESS				Engineering	
Part No. <u>D3205-1</u>		Cross tube				Water Jet	
NCR No. <u>19- 7243</u>		Skid-tube				Prod. Eng. Coord.	
Date: <u>19/05/27</u>		Machining				Rec/Store/Packaging	
Step #: <u>110</u>		Thermoforming				Supplier	
Description Work Order Deviation		Disposition				MRB (QS1042) Approval	
QTY Effective: <u>1</u>		Rework				DAS <u>55</u> 9-89 <u>19/06/06</u>	
Suspected Unapproved		Scrap				Completed By	
Use-as-is		Use-as-is				DAS <u>57</u> 9-89 <u>19/05/27</u>	
Suspected Unapproved		Use-as-is				Lead hand / Supervisor	
Suspected Unapproved		Use-as-is				Approval Verification	
Suspected Unapproved		Use-as-is				QC / QA Coordinator	
Suspected Unapproved		Use-as-is				Approval	
Suspected Unapproved		Use-as-is				9-89 <u>68</u> <u>19/05/27</u>	
Suspected Unapproved		Use-as-is				MAY 27 2019	

Root Cause		FAULT CATEGORY									
Environment	No Re-verification	Pressure/Forced	Temperature/Cure	Power Loss/Surge	Positioned Wrong						
Design	Operator	Bending	Set-up	Folio/Program	Outside Dimensions						
Doc/Data	Offset/Setup	Centre Not Concentric	BOM/Route	Grain	Over/Under tolerance						
Equip/Tooling	Supplier	Cracks	Broken/Damage/Defect	Weld	Part Incorrect						
Handling/Pre	Training	Crimp/Kink/Ripple/Wave	Inspection Incomplete/Unqualified	Wrong Stock Pulled	Part Lost/Missing						
Material	Use for Testing	Cuffs	Contamination	Out of Sequence	Part Moved						
Internal Transport	Poor Information	Crushing	Countersink	Off-set	Drawing						
Tribal Knowledge	Rushing	Heat Treat	Cut Too Short	Mislabeled	Finish						
LOA	Product Improvement	Wave/Twist in Tube	Instructions Incomplete/Unclear	Fit/Function	Misread						
Substation	Process Improvement	Marks/Chatter	Drill Holes	Misaligned/off center	Turning Sequence						
Past Expiry Date	Manufacturing Process										
Misidentified	Past Due										
OTHER :											